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URGENT

RBT400203
Job Sheet 191815



Part No: RBT400203

Job Qty: 2 pcs

Part Name: TRIM TAB BENDING GAUGE



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/19

Job Tracking No:

Due Date: 3/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400203 Rev.5 IPP Rev. A 19.01.21 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S168551



Part: RBT400203

Job No: 191815

Serial No/Batch: S168551

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/02/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/28/19		0.00	0.40	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/28/19		0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 40		
								APR 02 2019	
120	Packaging 3-1 - Stock - B4B	2 pcs	3/28/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	2 pcs	3/28/19		0.00	0.00	QC 21 - FG - 21		DAS 21 9-89
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 100 - Assemble as per DWG. See note 1.
 Descriptions: 110 - See note 1.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90087A145	Pan Head Screw 6-32 X 5/16	6 (3 ea)	100-Small Fab - 1	5164048
AN470AD-4-6 5+310	Rivet	8 (4 ea)	100-Small Fab - 1	5147499-1
MS21042-3	Nut use MS21042L3 per QSI 017	4 Ea (2 ea)	100-Small Fab - 1	5144952
MS24693-S272	Screw	4 Ea (2 ea)	100-Small Fab - 1	5074201
NAS1149F0363P	Washer	4 Ea (2 ea)	100-Small Fab - 1	5075390
NAS1149FN632P	Washer	6 Ea (3 ea)	100-Small Fab - 1	5053954
RBT400203-E	Spring	2 pcs (1 ea)	100-Small Fab - 1	5165378
RBT400203-F	Doubler	2 pcs (1 ea)	100-Small Fab - 1	5165374
RBT400203-G	Plastic Bumper	2 pcs (1 ea)	100-Small Fab - 1	5162390
RBT400203-H	Bumper	6 pcs (3 ea)	100-Small Fab - 1	5161743
RBT400203-J	Teflon Tape	2 pcs (1 ea)	100-Small Fab - 1	5165455
RBT400203-K	Weldment	2 pcs (1 ea)	100-Small Fab - 1	5165560

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90087A145	6	0	0
	AN470AD-4-6	8	0	0
	MS21042-3	4	682	0
	MS24693-S272	4	645	0
	NAS1149F0363P	4	461	0
	NAS1149FN632P	6	97	0
	RBT400203-E	2	0	0
	RBT400203-F	2	0	0
	RBT400203-G	2	0	0
	RBT400203-H	6	0	0
	RBT400203-J	2	0	0
	RBT400203-K	2	0	0

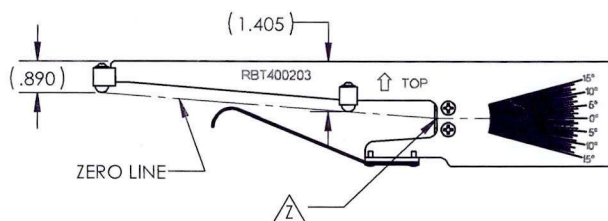
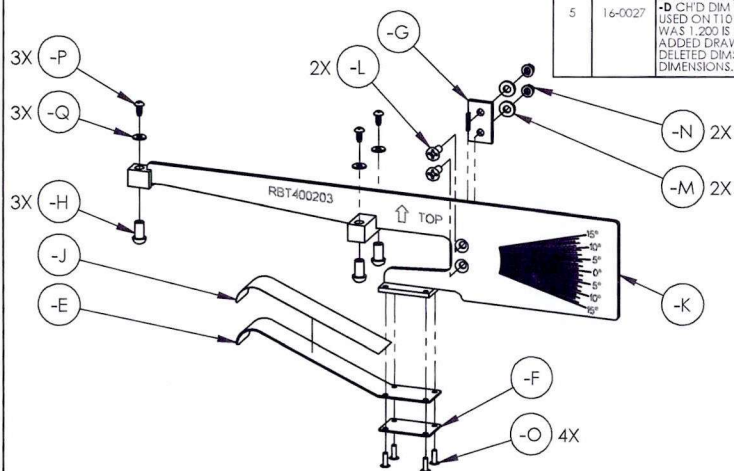
Part Specifications

Specifications could not be found.

Plex 3/8/19 2:48 PM Dart.lajeunesse.marie

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		INSTALLED NEW TITLE BLOCK & BOM FORMAT, CHANGED P/N FROM 206-215-002-101, AND ALTERED FROM ONE 11x17 PAGE TO THREE 8x11 PAGES, ALSO CHANGED FROM MIL SPEC HARDWARE.	8/28/2007	WP
2		ADDED OUTSIDE RADIUS TO -E AND -F.	1/9/2008	WP
3		REMOVED -E FLAT LAYOUT AND SUPPLIED MISSING OVER ALL DIMENSION.	4/20/2009	WP
3A		DELETED ASSY NOTES 1 & 2, ADDED -K WELDMENT TO BOM, CH'D WELDMENT FROM -A WELDMENT, DELETED NOTES 1, 2, & 3, CH'D FINISH FROM P.C. SAFETY YELLOW, MOVED PARTS TO SEPARATE SHEETS PER R.W.	8/11/2011	RJC
4		-E ADDED +/- .030 LIMITS TO DIMS (1.50, 5.76, .54, R.5), ADDED MISSING ANGLE DIM 22°, -B CH'D DIM WAS .125 IS .126 +.005/- .000, -A CH'D COUNTERBORE CALLOUT WAS 82° IS 82° X Ø.375, -K ADDED .515 DIM.	2/13/2013	BM
5	16-0027	UPDATED TO NEW STANDARDS. -A CH'D DIMS WAS 2X Ø.188 THRU 82° X Ø.375 IS 2X Ø.196 THRU ALL Ø.39 X 100°, WAS 3X R.250 IS 4X R.25. ADDED ENGRAVE S/N, "MADE IN USA" NOTE. -B CH'D DIMS WAS Ø.250 IS Ø.2500-2509, WAS .126 +.005-.000 IS .142-150. -C CH'D DIMS WAS 2X Ø.250 IS 2X Ø.2500-2509, WAS .126 +.005-.000 IS .142-150, WAS .69 IS .68, WAS 1.500 IS 1.50. ADDED DIM 2X .25. -D CH'D DIM WAS .125 IS .13. -E CH'D TO SHEET METAL TOLERANCES, DELETED SAME SPRING CLIP USED ON 1101656 NOTE. -F CH'D DIMS WAS .150 IS 2X .150, WAS .700 IS 2X .700, WAS .150 IS 2X .150, WAS 1.200 IS 2X 1.200. -G CH'D DIM WAS .372 IS 2X .372. -H CH'D DIM WAS Ø.252 IS Ø.2484-2490. -J ADDED DRAWING, ADDED B/O REF PORT PLASTICS #6093-10, -K CH'D DIM WAS 1.00 IS (1.00), DELETED DIMS .515, .250, .250, 2.000, 5.00. ADDED DIM .44. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	2/9/2016	DPD



NOTE:

1. POINT Δ IS ALSO CENTER LINE FOR 0°, AND CENTER POINT FOR DEGREE ARC.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	1		-A		GAUGE PLATE	6061		3
	1		-B		END BEARING PLATE	6061		4
	1		-C		DOUBLE BEARING PLATE	6061		5
	1		-D		SUPPORT PLATE	6061		6
			-E	1	SPRING CLIP	301 S.S.		7
			-F	1	DOUBLER	301 S.S.		8
			-G	1	STOP	WHITE DELRIN/ACETAL		9
			-H	3	BEARING	WHITE DELRIN/ACETAL		10
			-J	1	TEFLON TAPE	TEFLON	1" (PORT PLASTICS #6093-10) MODIFIED	11
X			-K	1	WELDMENT GAUGE PLATE			2
	B/O		-L	2	FLAT HEAD MACHINE SCREW	STEEL	10-32 X 1/2 (MS24693S272)	1
	B/O		-M	2	FLAT WASHER	STEEL	#10 (AN960-10)	1
	B/O		-N	2	SELF LOCKING NUT	STEEL	10-32 (MS21042-3)	1
	B/O		-O	4	RIVETS	ALUMINUM	Ø1/8 X 3/8 (AN470AD-4-6)	1
	B/O		-P	3	SELF THREADING PAN HEAD SCREW	STEEL	6-32 X 5/16, TYPE F (MCMASSTER-CARR #90087A145)	1
	B/O		-Q	3	FLAT WASHER	STEEL	#6 (AN960-6)	1
ASSY -K								

DART AEROSPACE

TITLE: TRIM TAB BENDING GAUGE

DWG NO. RBT400203 REV 5

MAT'L: ☐ ALU ☐ STEEL ☐ INCHES ☐ FRACTIONS ☐ DECIMALS

FINISH: ☐ XX ☐ XX ☐ X

SPEC: ☐ .015 ☐ .015R ☐ .015R

DRAWN BY: COLE

CHECKED: CLOUGH

OPPS APPR: ANDERSON

QA APPR: LINDSAY

APPROVED: MACKOVJAK

SCALE: 1:4 DATE: 1/10/2002 SHEET 1 OF 11

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

1. BREAK ALL SHARP EDGES

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL BELL 206

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 191815 M05

19-03-11

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					